

Date: Wednesday, 07/01/2009 1:52:30 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : REPLACEMENT ENGINE MOUNT KIT
<b>Job Number</b> : 44426	
<b>Estimate Number</b> : 13253	
<b>P.O. Number</b> :	<b>Part Number</b> : D205770011
<b>This Issue</b> : 07/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : IIN205-770 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 07/01/2009 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44425	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/01/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.09</u>	
<b>Comment</b> : Est Rev:A new issue ECN1165p 08-03-31 DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*Hg for JUD 09/02/02*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

*5 09/05/04*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3684043	MOUNT ASSEMBLY
-----	----------	----------------



*(K)*

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MOUNT ASSEMBLY

batch: *44523*

*9/5/4*

*SL*

4.0	D3684045	INBOARD LEG ASSEMBLY
-----	----------	----------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LEG ASSEMBLY

batch: *B44524*

*88 09/04/30 (XU)*

5.0	D36921	SPACER
-----	--------	--------



*(K)*

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: *B45524*

*9/4/14*

*SL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 07/01/2009 1:52:30 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT ENGINE MOUNT KIT

Job Number: 44426

Part Number: D205770011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolts

batch: M110155

9/4/14

54

7.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M111041

9/4/14

54

8.0

D3685041

BIPOD MOUNT ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BIPOD MOUNT ASSEMBLY

batch: B14525

9/5/14

54

9.0

D3686041

MONOPOD ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MONOPOD ASSEMBLY

batch: B14526

88 09/04/30 (X)

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 09/05/04 (X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-770-011 CHG001

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev A

88 09/05/04 (X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05 (X)

Job Completion



MF 09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#### 4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	107.8 in	1574 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	2.74 m	18.1 m-kg

#### 5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24426

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A

Date: 08.11.01

1	<b>D3685-041</b>	<b>BIPOD MOUNT ASSEMBLY</b>
1	*D3687-3	MOUNT
1	*D3684-047	FWD LEG ASSEMBLY
1	**D3688-1	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
1	*D3684-049	AFT LEG ASSEMBLY
1	**D3688-3	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
8	*D3692-1	SPACER
4	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	<b>D3686-041</b>	<b>MONOPOD ASSEMBLY</b>
1	*D3688-7	STUD
1	*D3689-1	SLEEVE
1	*D3691-1	STUD
4	*D3692-1	SPACER
4	*D3692-3	SPACER
1	*D3693-1	ROD END BEARING
1	*D3693-3	ROD END BEARING
2	*AN3C-10A	BOLT
2	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	*NAS509-12C	NUT
1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44426

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **A**

Date: 08.11.01